

# Work Order ID 79737

February-01-12 9:28:28 AM

*Handwritten:* HAI ONCE - ASAP  
\*79737\*

Page 1

Item ID: D4410-9 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Trigger  
 Start Date: 2/01/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 2/01/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: *[Signature]* Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4410	A U/R <i>[Signature]</i>								

100		0.00							
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**\*100\***

Waterjet Memo 0.00

FLOW CNC Waterjet

CUT AS PER DWG  
 DWG REV: *[Signature]*  
 PROG REV: *[Signature]*

DEBURR

*Handwritten:* B12-2-1

*Handwritten:* (3)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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**\*110\***

QC Memo 0.00

Quality Control

*Handwritten:* B12-2-1

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Item ID: D4410-9

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Trigger

Stop **\*NS2\***Start Date: 2/01/12 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 2/01/12 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start **\*NR1\***

QC: Date:

SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
<b>*120*</b>									
Mill Conv	Memo	0.00							
Conventional Milling Machine	MILL .125" RAD AND DRILL & TAP AS PER DWG								
	DEBURR								
125		0.00							
<b>*125*</b>									
QC	Memo	0.00							
Quality Control	QC2- Inspect parts off machine FAI/FAIB								
130		0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control	QC8- Inspect parts - second check								

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Item ID: D4410-9

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Trigger

Stop **\*NS2\***

Start Date: 2/01/12 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 2/01/12 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

170

Outsource process-Anodize per QSI017 4.1.10.1

0.00

**\*170\***

Outsource4

Memo

0.00

Outsource process - Anodize

Issue P/O: \_\_\_\_\_  
Black Anodize as per Dwg D4410

180

Receive & Inspect for Damage & Mat'l Certs

0.00

**\*180\***

Packaging

Memo

0.00

Packaging

spray paint black per Sizin h

190

QC3- Inspect Part Finish

0.00

**\*190\***

QC

Memo

0.00

Quality Control

At 12 - 2 - 2

W 12 01 03

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February-01-12 9:28:28 AM

Item ID: D4410-9

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Trigger

Start Date: 2/01/12 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 2/01/12 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start <b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:	Stop <b>*NR2*</b>

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

Identify as per dwg & Stock Location: *SHIP*

0.00

**\*220\***

Packaging

*SIAN*

0.00

Packaging

Memo

*Comp/8*

Packaging

230

QC21- Final Inspection - Work Order Release

0.00

**\*230\***

QC

Memo

0.00

Quality Control

*M.C.J. 12/02/08* *[Signature]**M.C.J. 12/02/08*  
*(3)*

# Picklist Print

February-01-12 9:28:27 AM

Page 1  
5

Work Order ID: 79737

Parent Item: D4410-9

Parent Item Name: Trigger

Start Date: 2/01/12

Required Date: 2/01/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 11-11-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.250		Purchased	No				sf	17.0000		0.0010526			
6061T6 SHEET .250													

Location

Loc Qty

Loc Code

MAT021

17

116808

17

116808

(3)

5 B12-1

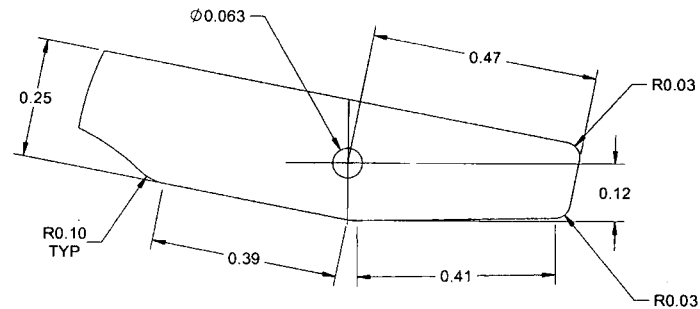
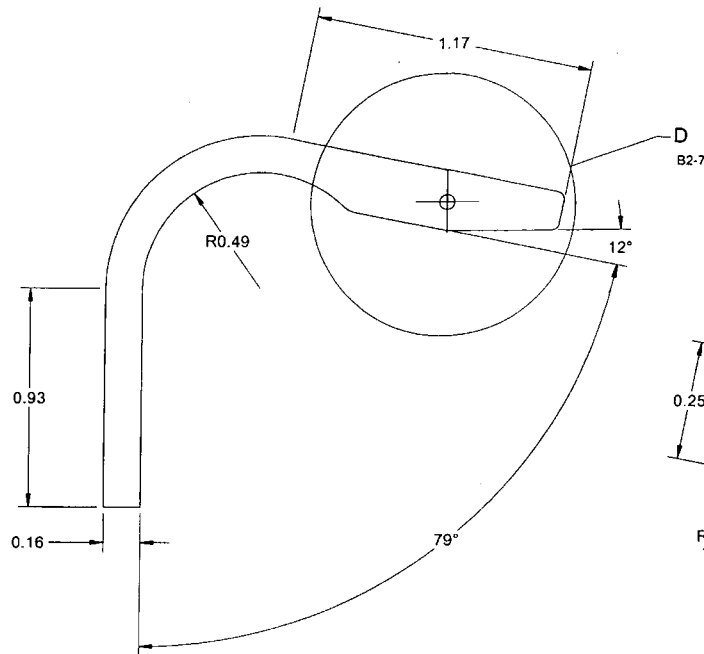
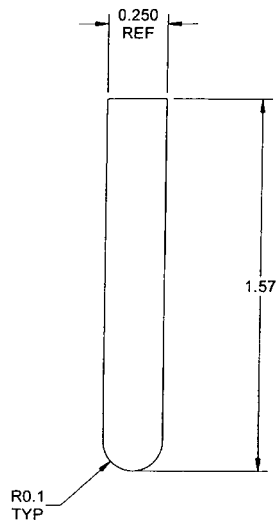
8 7 6 5 4 3 2 1

D

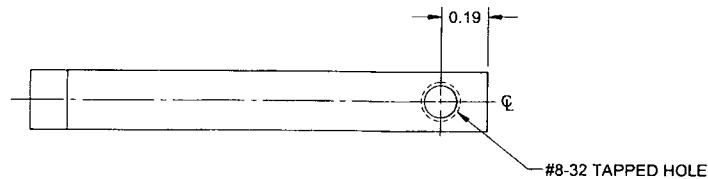
C

B

A



**DETAIL D**  
**SCALE 2X**  
D4-7



**D4410-9 TRIGGER**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.250 THK  
QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF. DART SPEC. M6061T6S.250
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

*w/p. 79737*

**RELEASED**  
2011-10-30

DESIGN	DC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	DC	KENT, WA	
CHECKED	SE	DRAWING NO.	REV. A
MFG. APPR.	SE	D4410	SHEET 7 OF 7
APPROVED	NO	TITLE	SCALE
DE APPR.	H	<b>CO-PILOT COLLECTIVE HEAD</b> NTS	
DATE	11.06.06	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

# FIRST ARTICLE INSPECTION CHECKLIST

PART AEROSPACE LTD		Work Order: 79737
Description: R. gge		Part Number: D4416-9
Inspection Dwg: D44109		Page 1 of 1

☒ First Article   
 ☒ Prototype

Drawing	Dimension	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
93	1.17	±0.03	1.17	✓		V	
93	1.16	±0.03	1.156	✓		V	
93	1.57	±0.03	1.576	✓		V	
93	1.256	±0.03	1.266	✓		V	

Measured by: B	Date: 12-2-1	Audited by: S	Date: 12/2/12	Prototype Approval:	Date:
Rev	Date	Change	Revised by	Approved	KJULM

FIRST ARTICLE INSPECTION CHECKLIST

Description: 719908		Part Number: 4410-9	
Work Order: 79737		Page 1 of 1	
Inspection Dwg: 4410		Rev: A	

☒ First Article   
 ☒ Prototype

Drawing	Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12	±.030	116	—	—	—	RA26 Vern	
147	±.030	1478	—	—	—	RA26 Vern	
119	±.030	199	—	—	—	RA26 Vern	
8x32	R.4	8x32	—	—	—		

Measured by: <i>MD</i>	Date: 12/02/01	Audited by: <i>S</i>	Date: 12/02/02	Prototype Approval: _____	Date: _____
Rev	Date	Change	Revised by	KJ/JLM	Approved
A		New Issue			